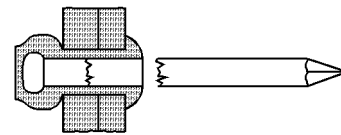
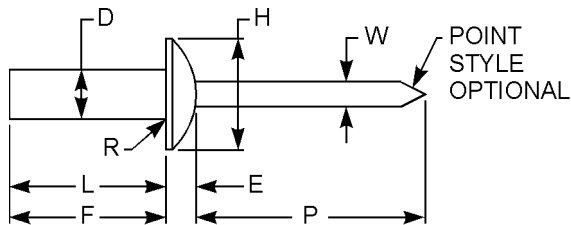


1. Introduction.

1.1 Scope. This standard establishes the dimensional, mechanical, and performance requirements of inch series break mandrel closed end blind rivets suitable for use in joining the component parts of an assembly. A metric series counterpart standard is in existence under designation IFI-509.

1.2 Definitions.

1.2.1 Blind Rivet. A blind rivet is a blind fastener which has a self-contained mechanical or other feature which permits the formation of an upset on the blind end of the rivet and expansion of the rivet shank during rivet setting to join the component parts of an assembly.



Properly Set Rivet

Table 1 Dimensions of Dome Head Style Break Mandrel Closed End Blind Rivets

Rivet Series No.	Nom Rivet Size	D		H		E	R	W	P	F	L
		Body Dia		Style 1 — Regular Head			Radius of Fillet	Mandrel Dia	Mandrel Protru-sion	Blind Side Protru-sion	Rivet Body Length
				Head Dia		Head Height		All Materials			
		Max	Min				Max	Min	Max	Max	Max
4	1/8 0.1250	0.128	0.122	0.252	0.224	0.050	0.025	0.074	1.00	Equal to "L" Rivet Body Length	See Table 2
5	5/32 0.1562	0.159	0.153	0.328	0.296	0.065	0.025	0.092	1.06		
6	3/16 0.1875	0.191	0.183	0.394	0.356	0.080	0.025	0.110	1.06		
8	1/4 0.2500	0.255	0.246	0.525	0.475	0.100	0.025	0.146	1.06		
See Notes							3			4	

NOTES:

- All dimensions are in inches.
- For application data, see Table 2.
- The junction of head and shank shall have a fillet with a max radius as shown.
- The blind side protrusion (F) equals the max length of rivet body (L) as given in Table 2 for the applicable grip. Minimum blind side clearance may be calculated by subtracting the actual grip (G) (i.e., the total thickness of the material to be joined) from the blind side protrusion (F). (Example: To join two plates each .100 in. thick with a 5/32 in. rivet, a No. 54 rivet would be used. Minimum blind side clearance necessary to permit proper rivet setting would be L – G, which is .500 – .200 and equals .300 in.).

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**Table 2 Application Data for Dome Head Style Break Mandrel
Closed End Blind Rivets**

Rivet Series No.	Nom Rivet Size	Recomm- ended Drill Size	Recommended Hole Size		Rivet No.	Grip Range	Rivet Body Length
			Max	Min			Max
4	1/8 0.1250	#30	0.133	0.129	41	.020 – .062	0.297
					42	.063 – .125	0.360
					43	.126 – .187	0.422
					44	.188 – .250	0.485
					45	.251 – .312	0.547
					46	.313 – .375	0.610
					48	.376 – .500	0.735
5	5/32 0.1562	#20	0.164	0.160	52	.020 – .125	0.375
					53	.126 – .187	0.437
					54	.188 – .250	0.500
					55	.251 – .312	0.562
					56	.313 – .375	0.625
					58	.376 – .500	0.750
6	3/16 0.1875	#11	0.196	0.192	62	.020 – .125	0.406
					63	.126 – .187	0.468
					64	.188 – .250	0.531
					66	.251 – .375	0.656
					68	.376 – .500	0.781
					610	.501 – .625	0.906
					612	.626 – .750	1.026
8	1/4 0.2500	F	0.261	0.257	82	.020 – .125	0.445
					84	.126 – .250	0.570
					86	.251 – .375	0.695
					88	.376 – .500	0.820
					810	.501 – .625	0.945
					812	.626 – .750	1.070
					814	.751 – .875	1.195
					816	.876 – 1.000	1.320
See Notes		2					

NOTES:

- All dimensions are in inches.
- Recommended drill sizes are those which normally produce holes within the specified hole size limits.

1.2.2 Break mandrel closed end blind rivets are pull mandrel type blind rivets where during the setting operation the mandrel is pulled within the rivet body and breaks at or near the junction of the mandrel shank and its upset end.

1.2.3 *Closed End.* The end of the rivet, as manufactured, is solid and remains closed on the blind side after setting.

1.2.4 Definitions of other terms used in this standard are given in IFI-110, *Glossary of Terms Relating to Blind Rivets*.

2. Designations.

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